Technical Data Sheet RLD8950V

January 2024
International Master - for professional use only

Product List

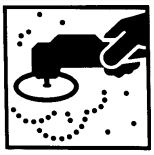
F895X Performance PU Primer	
Product	**Description**
F8952	Performance PU Primer – Light Grey
F8957	Performance PU Primer – Dark Grey
F8254	UHS Hardener – Slow
F8255	UHS Hardener – Medium
F8251	UHS Plural Mix Hardener
F8363	UHS Thinner – Extra Slow
F8364	UHS Thinner - Slow
F8365	UHS Thinner - Medium
F8358	UHS Plural Mix Thinner
F372	Medium Thinner

Product Description

Delfleet F895X Performance PU Primer is a high performance primer designed to give excellent corrosion protection over aluminium, and is especially recommended for surfaces of jointed aluminium panels.
It has a high build and can be applied in one coat over aluminium (2 coats required on steel). It can be recoated after 40 minutes and will give an excellent smooth finish and gloss from the topcoat.
The VOC content of this product is below 450 g/l.
It perfectly compliments the Delfleet One topcoat range, giving an excellent high quality finsh.

Substrates and Preparation

PREPARE THE SUBSTRATE AS FOLLOWS:



Substrates:	**Sanding:**
Steel	Abraded with P80-P150
Blast Cleaned Steel	SA 2.5 (Rz not above 35µm)
Aluminium	Abraded with P360-P400 or blast cleaned (Rz not above 35µm)
Chemically Pre-Treated Aluminium	Consult PPG Technical Team and see separate note
Galvanised Steel	Abraded with ScotchBrite® Red
Stainless Steel	Abraded with P80-P150
GRP	Abraded with P240-360
OE Finishes and Aged Paintwork	Abraded with P320-400

Cleaning:

The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe

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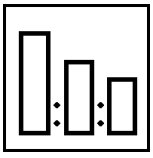
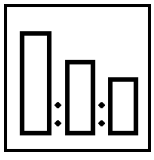
Process



Mixing Ratio by Volume:

	CONVENTIONAL OR PRESSURE-FEED APPLICATION	AIR-ASSISTED AIRLESS APPLICATION
F8952 Performance PU Primer	4	4
F8254 / F8255 UHS Hardener	1	1
F836X UHS Thinner	1.7- 2	0.8-1.2

PLURAL-MIX APPLICATION



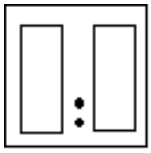
Mixing Ratio by Volume:

F8952 Performance PU Primer	3	3
F8251 Plural Mix Hardener	1	1
F8358 / F372 Thinner	1	0.5

Note: If pre-thinning the primer, ALWAYS use the F8358 or F372 Thinner

PRESSURE-FEED OR AIR ASSISTED AIRLESS APPLICATION – 2K Plural-Mix Equipment

For 2K Plural Mix Equipment it is recommended that the topcoat is pre-thinned, then the pre-thinned paint activated by plural mix. Please note that only F8358 or F372 should be used when pre-thinning the primer.



Pre-Thinning of Primer :

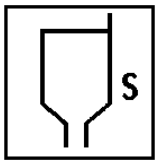
	CONVENTIONAL OR PRESSURE-FEED APPLICATION	AIR-ASSISTED AIRLESS APPLICATION
F8952 Performance PU Primer	3	3
F8358 or F372 Thinner	1	0.5

Activation of the Pre-Thinned Primer via Plural-Mix Equipment:

F8952 Performance PU Primer (Pre-Thinned)	4	3.5
F8251 Plural Mix Hardener	1	1

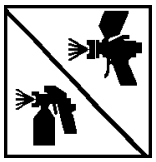
Application Process

CONVENTIONAL, PRESSURE FEED APPLICATIONPOT OR AIR ASSISTED AIRLESS APPLICATION



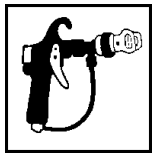
Spray Viscosity at 20°C:
17-19s DIN4 for Conventional/ Pressure Pot application
23-27s DIN4 for Air Assisted Airless Application

Pot Life: 1.5 hours (conventional spray) or 1 hour (air-assisted airless spray)



Gravity Feed: 1.3-1.4mm tip
Suction Feed: 1.6-1.8mm tip
Air Pressure : 2.0-2.5 bars

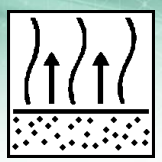
Pressure-Feed Application: 1.0-1.2mm tip
Paint Pressure: 0.3-1.0 bar Air Pressure: 2.0-2.5 bars
Fluid flow rate: 280-300 cc/min



Air-Assisted Airless Application:
Tip Size: 9-11 thou (0.23 to 0.28 mm)
Paint Pressure: 70-120 bars
Air Atomization Pressure: 2.0-3.5 bars

Number of Coats

For aluminium and non-metallic substrates, apply 1 full coat to give a Dry Film Thickness of 25-35 microns
For steel substrates, apply 2 full coats to give a minimum Dry Film Thickness of 50-80 microns
Higher film thicknesses are required on blast cleaned substrates.



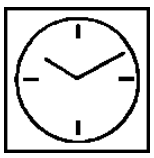
Flash-Off between 2 coats: 10-15 minutes minimum
Flash-Off before recoat: Minimum 40-60 minutes at 20°C before topcoating
If baking is required, flash-off 10 minutes minimum before baking 45-60 minutes at 60°C metal temperature.

Drying Time:

Ready for topcoat after 40-60 minutes, or up to 3 days with no sanding required.
For best results recoat wet-on wet

For best results recoat wet-on wet
Can be de-nibbed or lightly sanded if required, after 2-4 hours air dry using P360-500 abrasive.
If full sanding is required, best results are obtained after a bake or an overnight air dry.

Recommended Hardener / Thinner Combinations



Recommended combinations:

Temperature	<18°C	18-25°C	25-35°C	>35°C
Hardener	F8255 / F8251	F8255 / F8251	F8254 / F8251	F8254 / F8251
Thinner	F8365 / F8358	F8364 / F8358	F8364 / F8358	F8363 / F8358

Overcoating

Can be recoated with topcoat after 40-60 minutes air dry, or up to 3 days with no sanding required (if not baked).

Overcoat with: Any DELFLEET ONE® Topcoat, Delfleet UHS Topcoat, Deltron Solventborne Basecoat, or Envirobase HP.
Can also be recoated with F491X Wet on Wet Primer, or F392 HB Surfacer if required.

Application Over Chemically Pre-treated Aluminium

PPG F895X Performance PU Primer will work on some aluminium pre-treatments. Conditions of use are important. Please contact PPG Technical Support for more information.

Technical Data

Activation ratio by volume	4:1:1.7	4:1:1	3:1:1	3:1:0.5
F895X Performance PU Primer	4	4	3	3
F8255 / F8255 Hardener	1	1		
F8251 Plural Mix Hardener			1	1
F83XX Thinner	1.7	1	1	0.5
Volume solids %	49%	54.5%	50.7%	56.3%
Solids by weight %	68.6%	73.1%	69.0%	73.6%
Density	1.42	1.49	1.44	1.50
VOC (g/L)	446	400	444	394
Coverage m^2/L at 25 microns DFT	19.6	21.8	20.3	22.5

Health and Safety

The EU limit value for these products (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre.
Depending on the chosen mode of use, the actual ready to use VOC of these products may be lower than that specified by the EU Directive code.

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: www.ppgrefinish.com

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